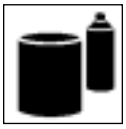
DuPont Automotive Finishes

DuPont™ DTM EPOXY PRIMER/SEALER V-2910S VS1

Description

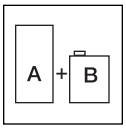
DuPont 2.1 VOC DTM EPOXY PRIMER/SEALER a two-component, non-isocyanate non-sanding primer with superior corrosion resistance and excellent adhesion for direct-to-metal applications. 2.1 VOC DTM is currently available in white. It is intended for use as a metal treatment under DuPont primer surfacers, or a sealer over DuPont primer surfacers. DTM can be applied over cleaned aluminum, galvanized steel,and stainless steel, or over appropriately sanded or blasted carbon steel, sanded fiberglass, and sanded OEM e-coat primers.

General Information



Components

V-2910S -	2.1 VOC DTM Epoxy Primer/Sealer LF (White)	VS 1
V-2905S -	DTM Mid-Temp Activator	
V-2907S -	DTM High-Temp Activator	



Mix Ratio/Viscosity

Mix Ratio (2:1)

Mix 2 parts 2.1 VOC DTM PRIMER to 1 part Activator

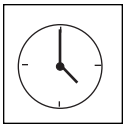
	Weight (Cum. Qt.) 2905S	Weight (Cum. Qt.) 2907S	
V-2910S	1030 grams	1030 grams	
V-290XS	1368 grams	1369 grams	(sprayable quart)

Viscosity

20 - 22 seconds in a Zahn #2 cup.at 2:1.

Tips For Success

Apply one medium wet coat. Film build dry should be 0.8-1.0 mils as a non-sanding primer/sealer over aluminum, galvanized steel, carbon steel and stainless steel. Time to topcoat is 30-40 minutes. Two coats of primer will build film build quickly and slow down the dry time to topcoat to 60 minutes. Can apply up to 2 coats (2.0-2.2 mils) as non-sanding primer/sealer.



Pot Life

12 hours at 70°F in a sealed container.

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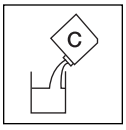
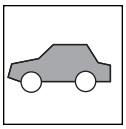


Additives

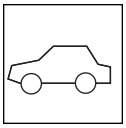
Reducer:	Up to 5% 12375S/12385S/12395S (In areas where 2.8 VOC is required)
Accelerator:	Not recommended.
Fish Eye Eliminator:	Not recommended.
Retarder:	Not recommended.



Topcoats

ChromaPremier® Basecoat
ChromaPremier® Single-Stage
ChromaBase® Basecoat
ChromaOne® Single-Stage
Centari® Single-Stage
Imron® 5000 Single-Stage
Imron® 6000 Basecoat
Imron® Single-Stage

Application



Substrates

Properly sanded OEM replacement parts
Properly sanded or blasted steel.
Properly cleaned or sanded aluminum, galvanized, and stainless steel
SMC, fiberglass, body fillers, polyester putties
Over properly sanded DuPont primers.
Under all DuPont primers.

Surface Preparation

n Clean painted surfaces thoroughly with mild detergent and water.

n For substrates other than plastic or fiberglass, clean surfaces with Prep-Sol® 3909S.

n For rigid plastic or fiberglass, wipe with Plastic-Prep® 2319S or 2320S.

n For flexible fascia, refer to the DuPont Plastics Refinishing System

1. To Use 2.1 VOC DTM Epoxy Primer/Sealer as a Precoat:
   Finish sanding with 320 grit paper or finer.
   Final cleaning should be done with 3909S.
2. To Use 2.1 VOC DTM Epoxy Primer/Sealer as a non-sanding primer:
   For application to OEM replacement parts, sand with 320 grit or finer.
   For application direct to steel, sand with 80 grit followed by 180 grit or finer.
   For application to aluminum, galvanized or stainless steel, clean with 3909S or sand with 320 grit paper or finer.
   Remove sanding sludge with 3909S.

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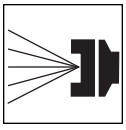
Gun Setups*

Conventional

Siphon Feed:	1.6 mm - 1.8 mm (.063” - .071”)
Gravity Feed:	1.4 mm - 1.6 mm (.055” - .063”)
Pressure Feed	1.0mm - 1.2 mm

HVLP

Siphon Feed:	1.9 mm - 2.1 mm
Gravity Feed:	1.4 mm - 1.5 mm
Pressure Feed:	.8mm - 1.0mm (Set fluid flow 10-12 oz per minute)



Air Pressure*

Conventional

Siphon Feed:	35 - 45 psi @ the gun.
Gravity Feed:	30 - 40 psi @ the gun.
Pressure Feed	35 - 40 psi @ the gun (Set fluid flow 12-14oz per minute)

HVLP

Siphon Feed:	8 - 10 psi at the gun cap.
Gravity Feed:	8 - 10 psi at the gun cap.
Pressure Feed:	8 - 10 psi at the gun cap.

*The listed setups cover the usual range for various application equipment. For information on specific manufacturers’ equipment, see the Appendix section titled “Equipment Information.”

Application

Apply 1 medium wet coat.

Flash/Dry Times

Air Dry

Nib Sanding:	30 - 60 minutes
Topcoating:	30 - 40 minutes (1 coat DTM) 50 - 60 minutes (2 coats DTM)

Force Dry

Flash before Force Dry:	5 minutes
Cycle Time:	20 minutes @ 140°F
Cool Down:	15 minutes

Infrared Dry — Refer to the Infrared Guide for setup recommendations.

Note: For use under body filler, allow to dry overnight (minimum of 16 hours) or bake 20 min @ 140°F.

Tips For Success

Ambient air temperature (greater than 70°F) and air flow will maximize product performance.

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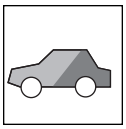
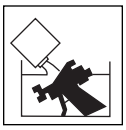


Recoatability/Re-repair

2.1 VOC DTM may be recoated at any stage of cure. DTM can be topcoated within 2 days air dry without sanding the DTM. If the DTM is baked or air dried longer than 2 days, it must be sanded with P400-P600 before topcoating



Cleanup

Clean spray equipment as soon as possible with DuPont Lacquer Thinner.

Physical Properties

VOC: 2.1 lbs/gal ready-to-spray.
Theoretical Coverage: 555 sq. feet per ready-to-spray gallon at 1 mil.
Volume Solids: 35% ready-to-spray.
Recommended Dry Film Thickness: 0.8 - 1.2 mils.
Flash Point: See MSDS.

VOC Regulated Areas

These directions refer to the use of products which may be restricted or require special mixing instructions
in VOC regulated areas. Follow mixing and usage recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

Before using any DuPont Refinish product, be sure to read all safety directions and warnings. WEAR A PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. Do not permit anyone without protection in the painting area. This product is intended for industrial use only by professional, trained painters.